



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4709-1

Job Sheet 172983



Part No: D4709-1

Job Qty: 10 ea

DAS
21
9-89

Part Name: Spring Clip



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 12.09.11 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/3/18	0.00	0.00	Start Up Waterjet		18103/29
110	Waterjet	10 pcs		3/3/18	0.00	0.34	Waterjet1		18103/29
130	QC	10 pcs		3/3/18	0.00	0.00	QC8		38
140	Brake NC	10 pcs		3/5/18	0.04	0.53	Brake NC 1		9-89 DAS 38
150	QC	10 pcs		3/5/18	0.00	0.00	QC5		9-89 38
160	Packaging	10 pcs		3/5/18	0.00	0.00	Packaging3		9-89
170	QC21-SA	10 Ea		3/5/18	0.00	0.00	QC21		JUN 01 2018

Part Op
Descriptions: 110 - 1-Cut as per Dwg

DAS
21
9-89

JUN 01 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M301S22GA	301 SS Sheet - Full hard	.1000 sf (.01 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M301S22GA	0	3	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S056739



Part: D4709-1

Job No: 172983

Serial No/Batch: S056739

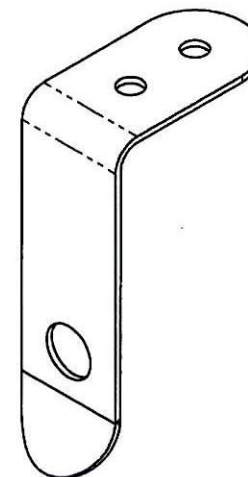
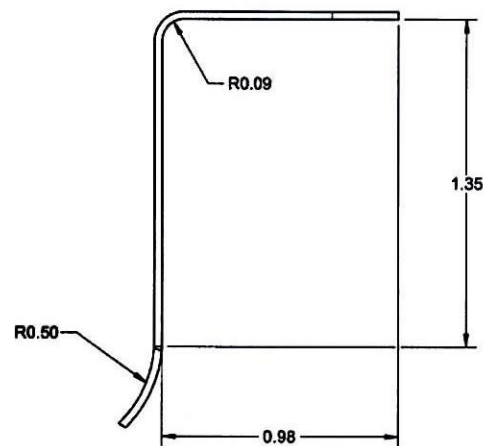
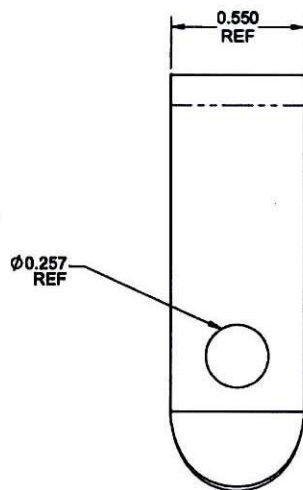
Revision:

Inspector:

Date: 03/29/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spring Clip	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Spring Clip	0.257Inches + 0.003 - 0.000	0.260 0.257	Diameter	
3	Spring Clip	0.550Inches $\pm$ 0.010	0.560 0.540		
4	Spring Clip	0.275Inches $\pm$ 0.010	0.285 0.265		
5	Spring Clip	0.375Inches $\pm$ 0.010	0.385 0.365		
6	Spring Clip	1.458Inches $\pm$ 0.010	1.468 1.448		
7	Spring Clip	2.604Inches $\pm$ 0.010	2.614 2.594		
8	Spring Clip	0.031Inches $\pm$ 0.010	0.041 0.021		

Plex 2/23/18 1:03 PM dart.logan.david



D4709-1 SPRING CLIP

RELEASED

2017 MAY 24
ECN 17-571

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172983

20180226

- NOTES:
- 1) MATERIAL: MAKE FROM D4709-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4709-1" AND B/N "BXXXX" PER QSI 044 6.7
 - 7) WEIGHT: 0.01 lbs

C	ADDED -3/4-3F	VS	17.02.01
B	MATERIAL NOW AISI 301 STAINLESS STEEL (FULL HARD CONDITION), THICKNESS NOW 0.031 THK (C2-2).	AP	12.11.22
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	DD	D4709	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SPRING CLIP	NTS
DATE	17.02.01	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED